

Work Order ID 80892-2 Split

Friday, March 02, 2012 2:57:55 PM

80892

Item ID: D4571-041

Revision ID:

Item Name: Tail Rotor Disabling

Start Date: 3/12/2012 Start Qty: 5.00

Required Date: 3/23/2012 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: CMF

QC:

Date: 12-03-02 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4571

100

100

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

110

110

Small Fab

Small Fab

Memo

ASSEMBLE AS PER DWG

0.00

0.00

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

FF
12/04/1012/04/12
FF

(4)

Work Order ID 80892

Friday, March 02, 2012 2:57:55 PM

80892

Page 2

Item ID: D4571-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tail Rotor Disabling

Start Date: 3/12/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/23/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location:

486

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

(42)

12/4/1650

12/4/19

mk
12-04-18

Picklist Print

Friday, March 02, 2012 2:57:55 PM

Page 2

Work Order ID: 80892

Parent Item: D4571-041

Parent Item Name: Tail Rotor Disabling

Start Date: 3/12/2012

Required Date: 3/23/2012

Start Qty: 5.00

Required Qty: 5.00

D3385-3 Manufactured No
Hinge

100 Each 78.0000 1 5

FF
12/04/10

Location

Loc Qty

Loc Code

ST041

78

22387

78

4

D4571-1 Manufactured No
Base

100 Each 0.0000 1 5

FF
12/04/10

D4571-3 Manufactured No
Cover

100 Each 0.0000 1 5

FF
12/04/10

MS51957-41 Purchased No
Screw

100 Each 58.0000 1 20

FF
12/04/10

Location

Loc Qty

Loc Code

ST295

56

120177

56

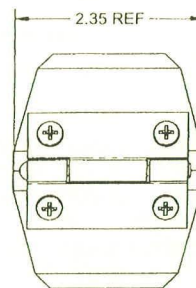
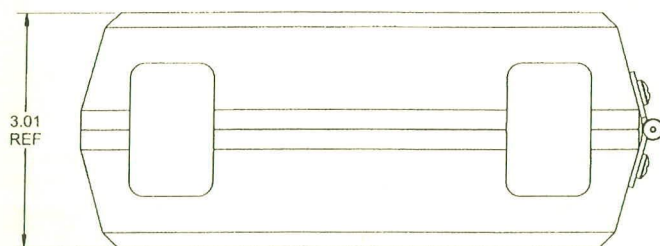
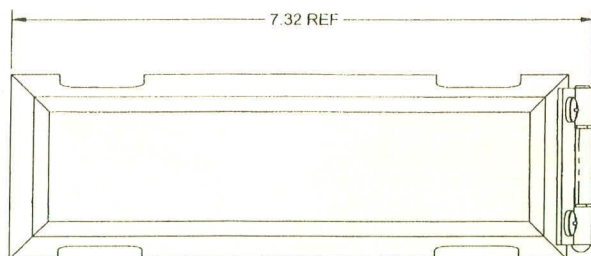
18

Friday, March 02, 2012 2:57:55 PM

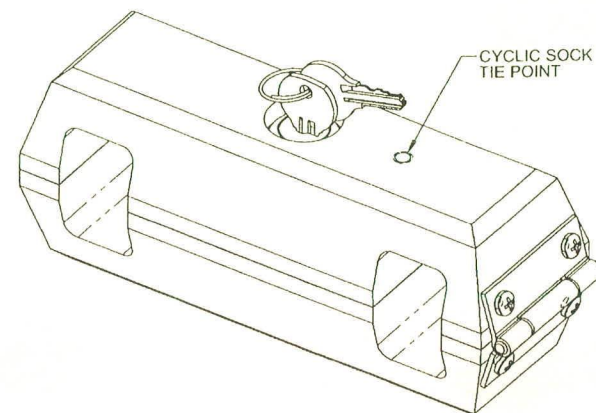
Shop Packet Print

Page 2

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
	1		D3384-047	CYCLIC SOCK
	1		MS 16995-47	SCREW, SKT-HD
	2		AN960-416	WASHER, FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4571-1	BASE
4		1	D4571-3	COVER
5		4	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMASTER CARR)



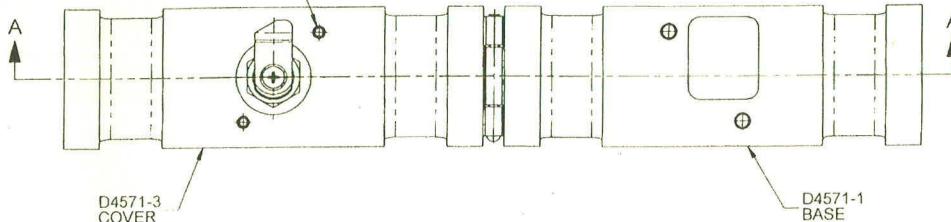
D4571-051 PEDAL LOCK



RELEASED
2012-01-30

B	ADDED CYCLIC SOCK AND RELATED HARDWARE TO BOM ADDED DIM 0.560, DELETED DIM 0.188 SHT 3 ADDED DIM 1.200, DELETED DIM 0.300 SHT 4	RP	12.01.23
A	NEW ISSUE	RP	12.01.06
REV	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4571	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

97395A461
DOWEL PIN (MCMaster CARR)



D4571-051 PEDAL LOCK ASSEMBLY

D3373-5
CAM LOCK ASSEMBLY
PEDAL LOCK

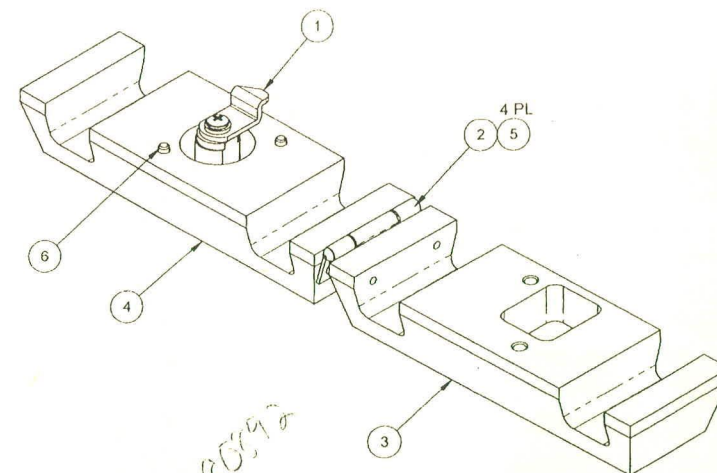
#10 LOCK WASHER REF
#10-32 PN -HD SCREW REF
(AS PER D3373-5)

0.10 TYP
REF

D3385-3
HINGE



SECTION A-A

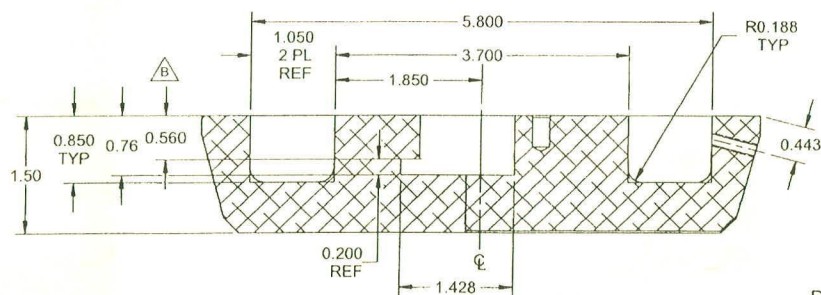
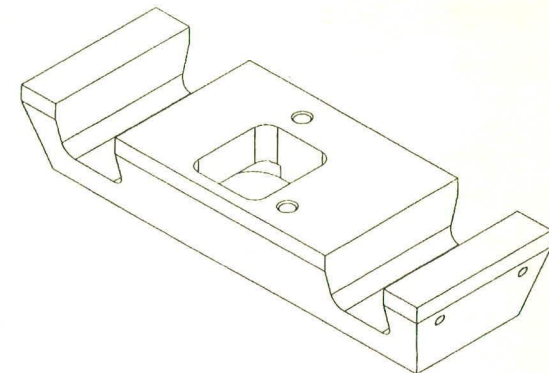
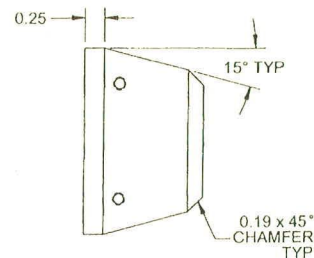
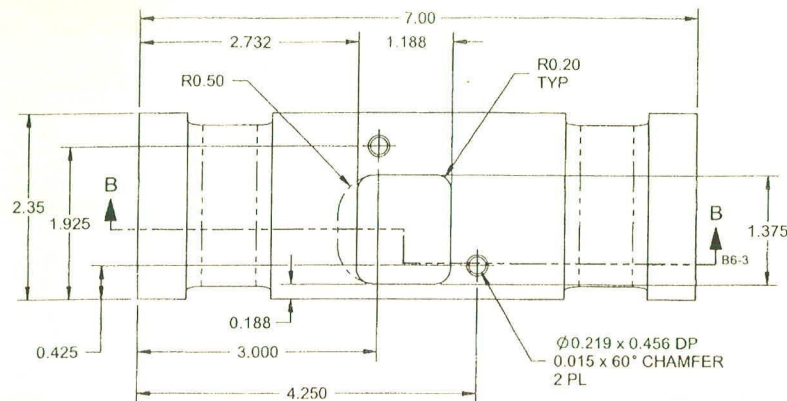


NOTES:

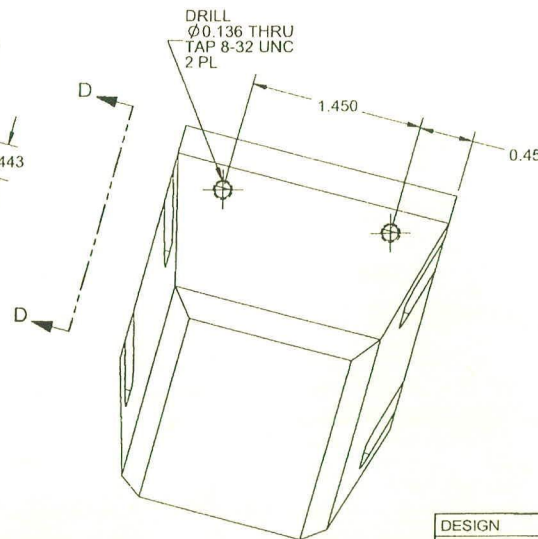
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO D4571	REV. B
MFG. APPR.	CE	SHEET 2 OF 4	
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, IN COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SECTION B-B C6-3





VIEW D-D

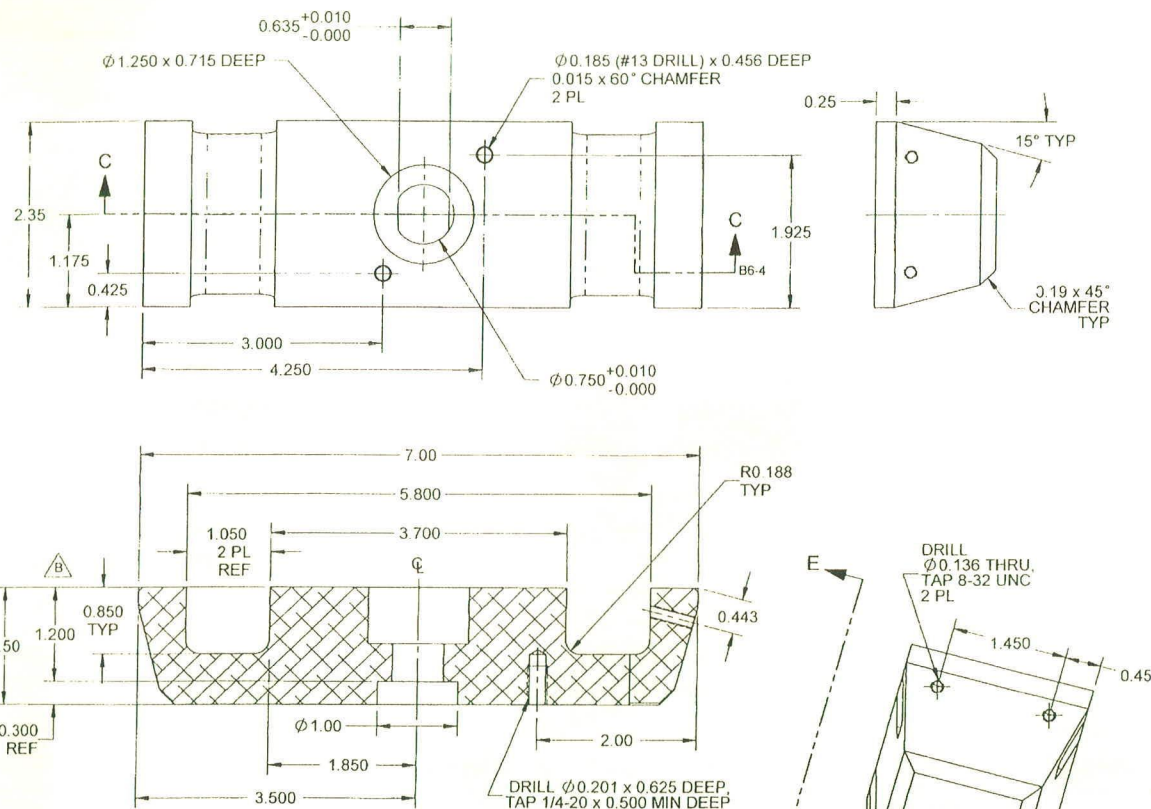
NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-1 BASE

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.		D4571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON OR "GROUP" WITHOUT PERMISSION FROM DART AEROSPACE LTD.			



SECTION C-C D6-4

VIEW E-E

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE PEDAL LOCK	SCALE NTS
DE APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION OF A NATURE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.01.23		

